

5/13

SLUT

DART AEROSPACE LTD	Work Order:	225246
Description: STA 84 bracket	Part Number:	D2803-2
Dwg: D2803 rev. <i>AB 05.02.21</i>	Qty:	20 12









Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue W/O	<i>HA</i>	05.02.23	20 12
2	METAL	Cut blanks per template DT 8533 Material: 6061-T6 bar 10.00" x 0.50" Batch: <i>M16933 m10627</i>	<i>J</i>	05.03.14	20 12
3	HAAS	Machine as per folio FA102	<i>SD</i>	05.03.14	20 12
4	QC	Inspect Level 2	<i>SD</i>	05.03.14	12
5	QC	Inspect Level 8	<i>EP</i>	05/03/23	12
6	METAL	Tumble & Deburr	<i>BL</i>	05/03/23	12
7	QC	Inspect Level 5	<i>EP</i>	05/03/23	12
8	FINISHING	Chemical conversion coat per QSI 005	<i>JG</i>	05/03/28	12
9	STORES	Identify and stock	<i>SB</i>	05/03/28	12
10	EXPEDITING	Close W/O Cost / part: <i>65.48 540 05/03/29 12</i>	<i>HA</i>	05.06.08	12

Rev	Date	Change	Revised By	Approved
A	00.11.06	New Issue	EC	<i>HA</i>

RELEASED

EC 00.11.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 22524		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/03/15	# 3	one Part scrap. extra MAT. Deflated the cut		destroy & replace	 05/03/22	 05-03-15	 per 05/12	 05/03/15
05-03-22	3	8 <sup>th</sup> pieces of 240" pocket milled at .240" instead of .250" which makes it .010" out of tolerance		for Heger 8 <sup>th</sup> parts only with face stop 0.010"				 05-03-15

Part No: D2803-2

PAR #:

Fault Category:

Prod / machines Parts

NCR:

Yes

No

DQA:



Date: 05/06/08

NOTE: Date &amp; initial all entries

QA: N/C Closed:

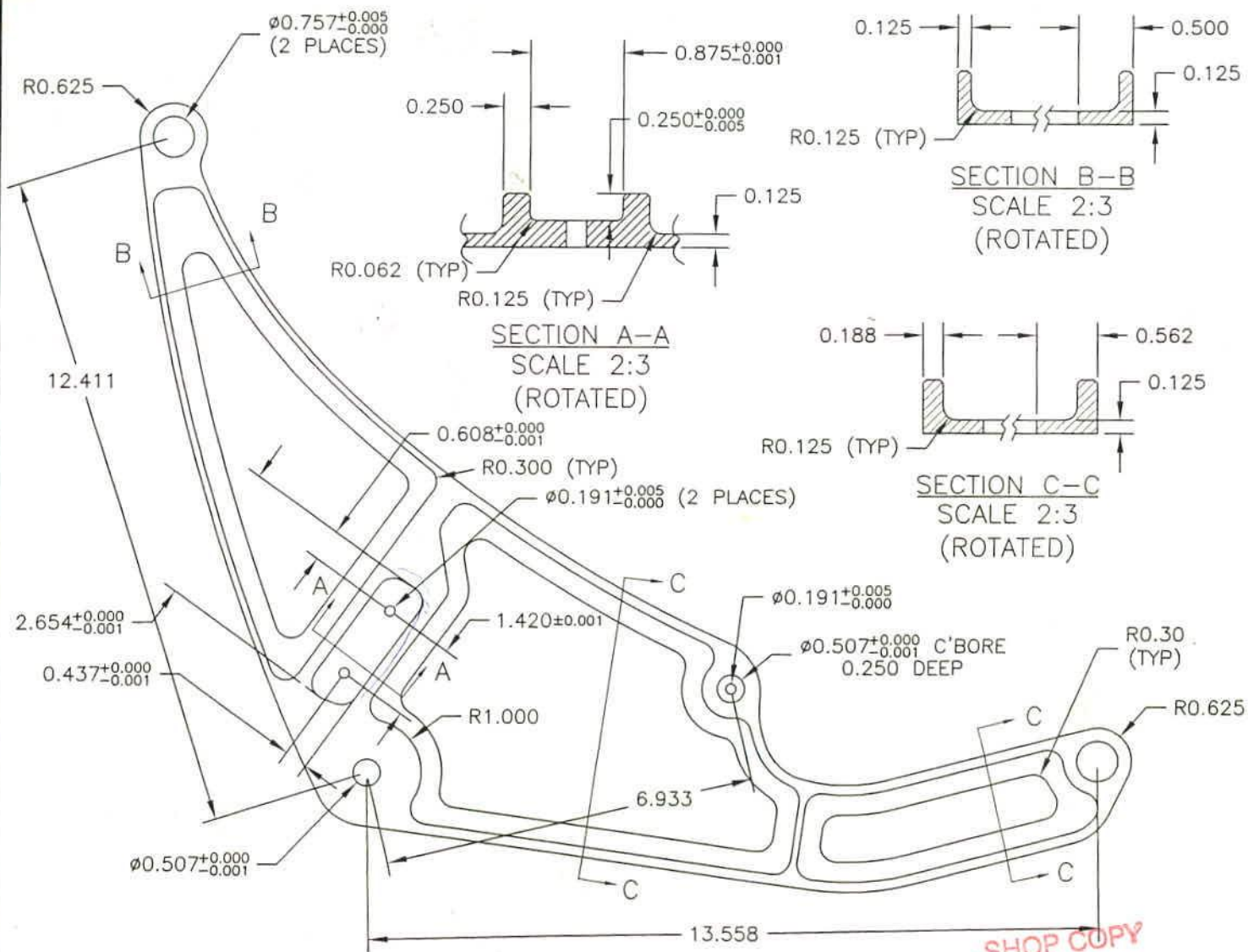


Date: 05.06.08



# PRELIMINARY ISSUE

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22	TITLE STA 84 BRACKET		SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	



## D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 22524

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Feb 22, 2005  
03:39 pm

Work Order No : 0022524  
Project Name : D2803-2  
Project For : WK513  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2803-2  
Description : STA 84 Bracket  
Manufactured : Yes  
Amount Req'd : 20  
Amount Done : 0  
Start Date : 02-22-05  
Est Finish Date : 03-15-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



DART AEROSPACE LTD		Work Order: 22524
Description:		Part Number: D2803-2
Inspection Dwg:	Rev:	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.757	+0.005 -0.000	.757	✓			Upr
1.420	±.001	1.419	✓			
Ø.191 x 3	<del>±.001</del>	.191	✓			
Ø.507		.507	✓			
Ø.507 x .250 dep		.507 x .251	✓			
12.411		12.410	✓			TAPK
13.558		13.560	✓			TAPK
6.933		6.930	✓			TAPK
.250		.253	✓			Upr
.875	+0.000 -0.005	.874	✓			
.250		.253	✓			
.125		.129	✓			
.125		.127	✓			
.500		.501	✓			
.125		.128	✓			
.188		.189	✓			
.562		.565	✓			
.125		.131	✓			

Measured by: SA	Audited by: MK	Prototype Approval: N/A
Date: 05.03.14	Date: 05/03/14	Date:

Rev: 8	Date:	Change: New Issue	Revised by: KJ/JLM	Approved:
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